

5/30

DART AEROSPACE LTD	Work Order:	23814
Description: Inner Fwd Saddle	Part Number:	D5953
Drawing: D5953 Rev. A	Qty:	12

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required</i>	PF	05.07.14	12
2	STORES	Issue material from stock: D6101-007 (7075-T7351) Cut Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: 1323250	ML	05/08/06	12
3	HAAS	Setup W/O No. Setup Inspection last completed	b	N/A	1
4	HAAS	Machine as per folio D5953 <b>Ensure Batch Number is entered</b>	ML	05/08/06	12
5	HAAS	Deburr and Tumble	ML	05/08/07	12
6	QC	Inspect Level 1 Fill Out Inspection Sheet	ML	05/08/07	12
7	QC	Inspect Level 8 Audit Inspection Sheet	SG	05.08.07	12
8	METAL	Acid etch and alodine as per QSI 005 4.1	ML	05/08/17	12
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	ML	05/08/17	12
10	QC	Inspect Level 3	DL	05/08/20	12
11	STORES	Pack in foam, identify and stock	DL	05/08/20	12
12	EXPEDITING	Close Work Order 164.98 Inspect level 21 Cost / Part: 161.25	AP	05/08/24	12
			(D)	05/08/20	12

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 No
 
 DQA: 

Date: 05/08/22

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	23814
Description: Inner Fwd Saddle	Part Number:	D5953
Inspection Dwg: D5953 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5953 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	—	—	—	—		
B	1.745	1.755		1.749	1.749	1.750	1.750		
C	5.245	5.255		5.250	5.250	8.249	5.250		
D	6.995	7.005		6.999	6.999	6.999	6.999		
E	5.745	5.755		5.749	5.749	5.749	5.748		
F	4.745	4.755		4.750	4.749	4.748	4.748		
G	0.313	0.318	DT8686	—	—	—	—		
H	1.522	1.532		1.526	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.055	3.055	3.055		
J	4.575	4.585		4.579	4.579	4.579	4.578		
K	0.313	0.318	DT8686	—	—	—	—		
L	0.240	0.260		0.254	0.253	0.251	0.251		
M	0.490	0.510		0.504	0.502	0.502	0.503		
N	0.240	0.260		0.254	0.251	0.255	0.255		
O	7.990	8.010		7.999	7.999	8.001	8.001		
P	0.240	0.260		0.242	0.256	0.256	0.257		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.495	0.497	0.506	0.503		
T	1.375	1.395		1.380	1.380	1.380	1.380		
U	2.000	2.020	DT8696 A/B	—	—	—	—		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	cm	Audited by:	ISG
Date:	05/08/07	Date:	05.08.08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF RF	#

RELEASED  
03.06.18 RF

DART AEROSPACE LTD	Work Order:	23814
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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.249	5.250	5.250		
D	6.995	7.005		6.999	6.999	7.000	7.000		
E	5.745	5.755		5.748	5.747	5.747	5.748		
F	4.745	4.755		4.748	4.748	4.747	4.748		
G	0.313	0.318	DT8686	—	—	—	—		
H	1.522	1.532		1.528	1.526	1.526	1.526		
I	3.048	3.058		3.051	3.052	3.052	3.053		
J	4.575	4.585		4.579	4.577	4.578	4.580		
K	0.313	0.318	DT8686	—	—	—	—		
L	0.240	0.260		0.251	0.252	0.250	0.250		
M	0.490	0.510		0.502	0.503	0.502	0.503		
N	0.240	0.260		0.253	0.254	0.255	0.254		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	0.240	0.260		0.257	0.258	0.258	0.255		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.501	0.503	0.503	0.502		
T	1.375	1.395		1.380	1.380	1.381	1.384		
U	2.000	2.020	DT8696 A/B	—	—	—	—		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	TM	Audited by:	TSG
Date:	05/08/07	Date:	05.08.07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF RF	

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A	0.438	0.443	DT8682	—	—	—	—		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	5.245	5.255		5.256	5.256	5.249	5.249		
D	6.995	7.005		7.000	6.998	6.999	6.998		
E	5.745	5.755		5.750	5.748	5.748	5.749		
F	4.745	4.755		4.750	4.748	4.748	4.749		
G	0.313	0.318	DT8686	✓	—	—	—		
H	1.522	1.532		1.527	1.525	1.526	1.527		
I	3.048	3.058		3.056	3.053	3.056	3.056		
J	4.575	4.585		4.579	4.579	4.580	4.579		
K	0.313	0.318	DT8686	✓	—	—	—		
L	0.240	0.260		0.250	0.249	0.248	0.248		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	0.240	0.260		0.255	0.253	0.256	0.253		
O	7.990	8.010		8.006	8.006	8.006	8.000		
P	0.240	0.260		0.258	0.255	0.256	0.253		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.502	0.503	0.502	0.503		
T	1.375	1.395		1.383	1.382	1.384	1.384		
U	2.000	2.020	DT8696 A/B	—	—	—	—		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JL</i>	Audited by:	<i>RG</i>
Date:	05/08/07	Date:	05.04.08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF <i>RF</i>	<i>#</i>

**RELEASED**  
03.06.18 *RF*

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyJul 14, 2005  
01:41 pm

Work Order No : 0023814  
 Project Name : D5953 Department Code:  
 Project For : WK530 Burden Flags : NNNNNNNN  
 Work Order Type : Main WO Status : Open  
 Main WO Number : Invoice State : Not Invoiced  
 House Part Number : D5953 Invoice Date :  
 Description : Saddle Invoice Number :  
 Manufactured : Yes Invoice Amount : 0.00  
 Amount Req'd : 12  
 Amount Done : 0 Order Entry No :  
 Start Date : 07-14-05 OE Value : 0.00  
 Est Finish Date : 07-30-08  
 Act Finish Date :  
 Drawings Reqd : No Est Mark Up : 0.000%  
 Ok for Approval : Actual Mark Up : 0.000%  
 Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00